

Date: Wednesday, 07/01/2009 1:34:43 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number	: 44468		
Estimate Number	: 10824		
P.O. Number	:	Part Number	: D412630032
This Issue	: 07/01/2009	Drawing Number	: IIN D412-630
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: L
Previous Run	: 44467	Material	:
Written By	:	Due Date	: 28/01/2009
Checked & Approved By	: <u>Jul 09.01.09</u>	Qty:	1
Comment	: EST. REV. A 05.11.21 NEW ISSUE EC	Um:	Each
	: EST. REV. B 05.12.19 updated pick list EC		
	: EST. REV. C 07.11.12 ecn 1019, nochg EC		
	: verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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S0162/10



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-034 CHG901.

-032 002

09.02.17

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

3.0	D3463042	Step Weldment Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-042	Step weldment	

38823.

44480

09/02/09

4.0	D3443043	Strut Weldment Assembly
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-043	Strut ass'y	

344483

09/02/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-041	Strut ass'y	41843

SS 09/02/09 (X)

6.0 D34439 Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3443-9	Pin	30220

SS 09/02/09 (X)

7.0 AN4CH3 SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN4CH3	BOLT	M101537
	A/R MS20995c41e	Lockwire	M104281

SS 09/02/09 (X)

8.0 AN4C14 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C14	BOLT	M103248

SS 09/02/09 (X)

9.0 D34547 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-7	Bushing	38781

SS 09/02/09 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44468

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 AN3104 NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	M107139

JS 09/02/09 (X)

11.0 MS24665227 COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	M109174

JS 09/02/09 (X)

12.0 D34551 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	38782

JS 09/02/09 (X)

13.0 D34651 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	411692

JS 09/02/09 (X)

14.0 AN3107 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	M103286

JS 09/02/09 (X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44468

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	M106763

SS 09/02/09 (X)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

S or L or U (X) RH

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	B33730

SP

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	B38171

SP

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	B34842

9/2/11

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44468

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation: Description :

21.0 D34551 Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
6 D3455-1 Spacer 1238782

50

22.0 D34553 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3455-3 Spacer 1230222

50

23.0 D3462042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3462-042 Bracket ass'y 1244487

50

24.0 AN3104 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN310-4 Nut 1107139

50

25.0 AN3105 NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN310-5 Nut 1105280

9/2/11

50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44468

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	AN3C5A	Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	M110468

SC

27.0	AN44C12	eyebolt
------	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN44-C12	Eyebolt	M110665

SP

28.0	AN4C15	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C15	BOLT	M103248

SC

29.0	AN5C11	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C11	BOLT	M103248

SC

30.0	AN5C15	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN5C15	BOLT	M110155

9/2/11

SC

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44468

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	AN960C10	WASHER
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Comment: Qty.: 7.0000 EACH(s)/Unit Total : 7.0000 EACH(s)

Pick:

Qty	Part Number	Description	Batch
7	AN960C10	Washer	M109146

50

32.0	AN960C516	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C516	Washer	M102842

50

33.0	MS210433	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	MS21043-3	Nut	M110023

50

34.0	MS24665227	COTTER PIN
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	M109174

50

35.0	MS24665229	COTTER PIN
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	M109174 9/2/11

50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 44468

Part Number: D412630032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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36.0	NAS1515H5	Washer
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EX

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H5	Washer	M109430 9/2/11

SP

37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

809/02/12 (4/12/11)

38.0	PACKAGING 1	PACKAGING RESOURCE #1
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EX

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location:

PPP Rev:

3/B

9/2/12

SP

39.0	QC21	FINAL INSPECTION/W/O RELEASE
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09/02/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6 09-02-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

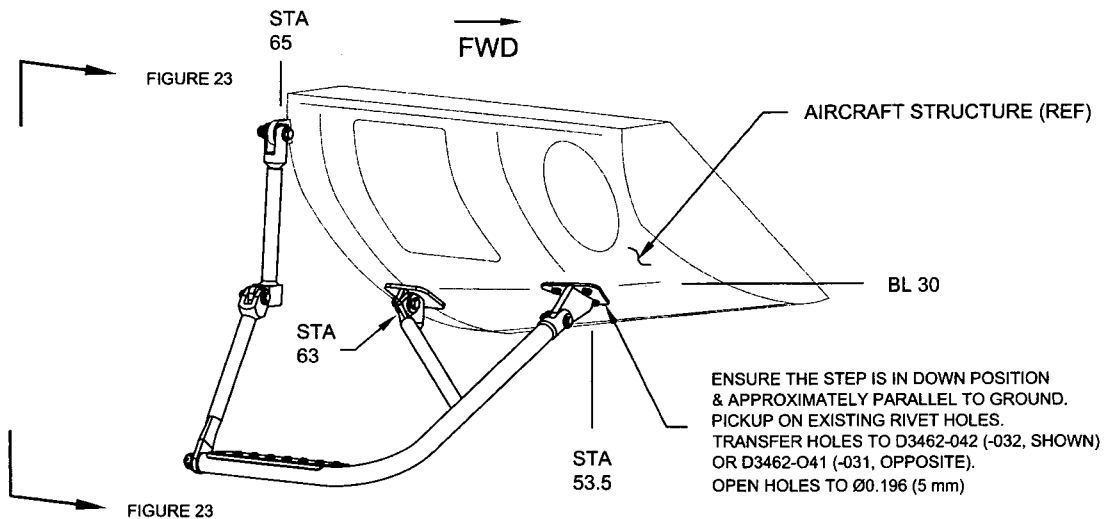
D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown), D412-630-031 LH (Opposite)

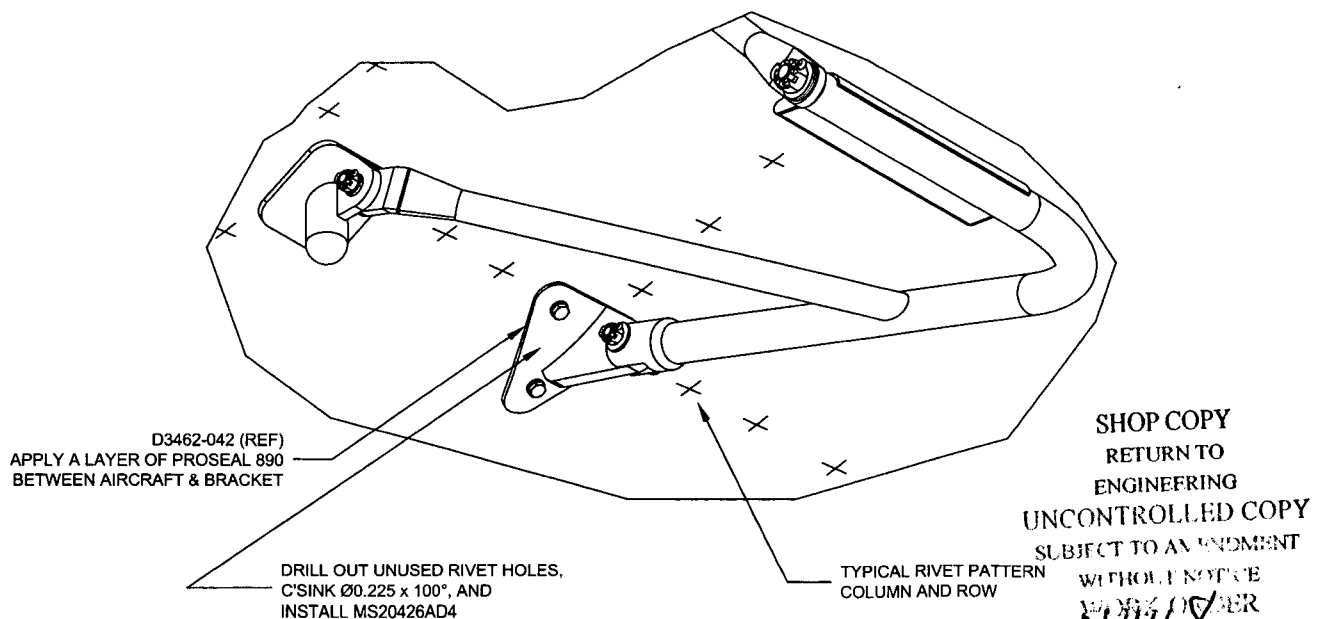
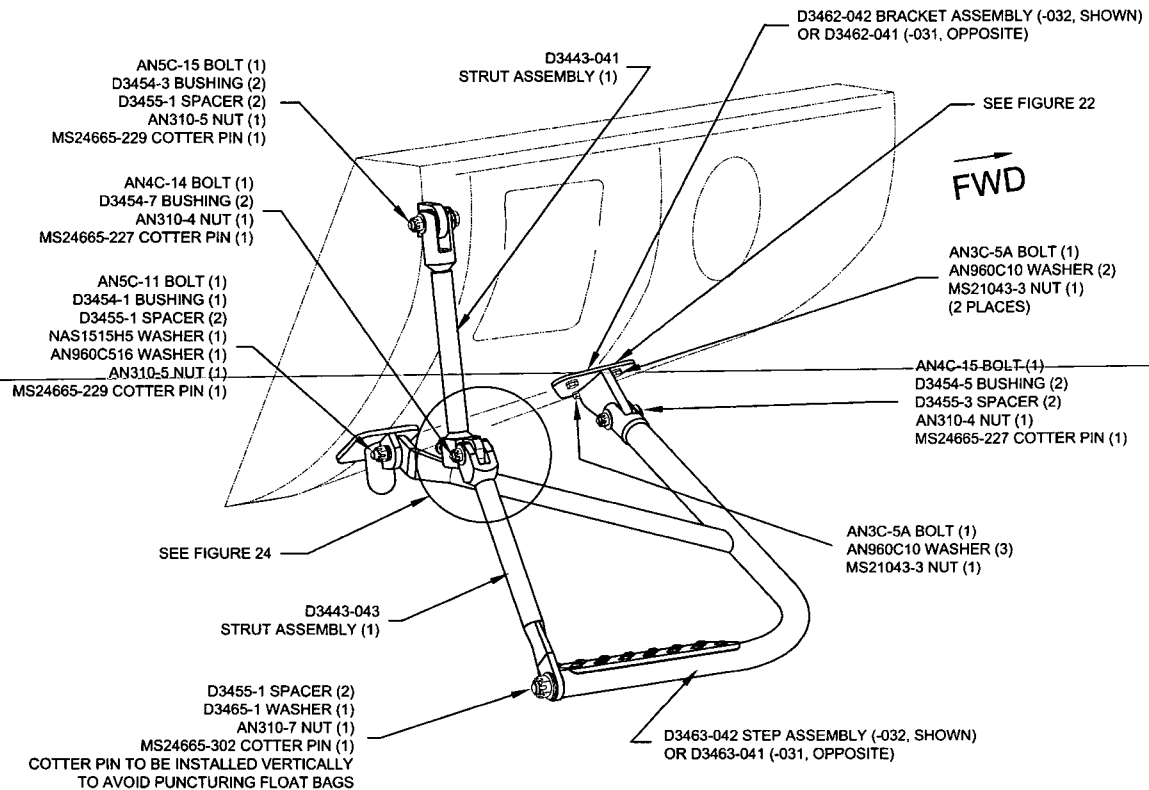


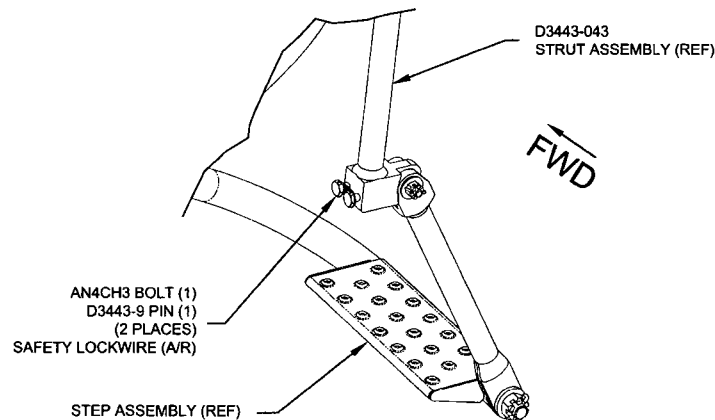
FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown) D3462-041, (-031 Installation Opposite)

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Revision: L
Date: 07.09.30



**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

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